

Date: Thursday, 05/02/2009 3:47:53 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 45581	
Estimate Number : 13743	
P.O. Number :	Part Number : D38683
This Issue : 05/02/2009 S.O. No. :	Drawing Number : D3868 PRELIM <i>rev. A</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : SMALL /MED FAB	Drawing Revision : <u>PRELIM</u> <i>w</i>
Previous Run : 44955	Material :
Written By :	Due Date : 20/02/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JD 09.02.06</u>	
Comment : Est Rev:A 09-01-19 as per prelim issue DD verified by:ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S040	6061-T6 .040 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.0125 sf(s)/Unit Total : 0.0750 sf(s)
 6061-T6 .040 Sheet
 batch: 102723

*ml 09 04 02**(6)*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

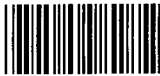


Comment: FLOW WATER JET
 1-Cut as per Dwg D3868
 Dwg Rev: A
 Prog Rev: A

2-Deburr if necessary

*ml 09 04 02**(6)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE*ml 09 04 02**(6)*

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK*Sort 0402**(x6)*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



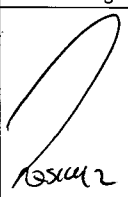
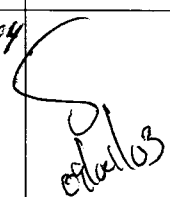
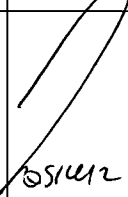
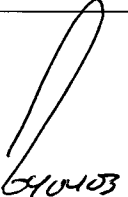
Comment: SMALL & MEDIUM FAB RESOURCE 1
 1- c'sink holes as per dwg D3868
 2- deburr

*FF 09-04-04**(5) PTO*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3868-3 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 05/04/06
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>45581</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/04/04	5	COUNTER SIN th TO DEEP ON FIRST SPACER (D38683) L.C. too set-up		Scrap NOT Replaced	09/04/04 FF			

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 3:47:53 PM
User: Julia Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 45581

Part Number: D38683

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

05/04/03 (X5)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BL 09-04-03 (6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/04/06 X5

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 8139-A

08 4 09/04/03 (X5)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/06

Job Completion



MF 09-04-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	45581
Description: SPACER	Part Number:	D3868-3
Inspection Dwg: D3868 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X

First Article

11

Prototype

[illegible]

Measured by: <i>mm</i>	Audited by: <i>S</i>	Prototype Approval: <i>a</i>
Date: <i>09/04/02</i>	Date: <i>09/04/02</i>	Date: <i>4</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

